

Work Order ID 86867

86867

Page 1

July-06-12 3:18:23 PM

Item ID: D2970-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 7/06/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

120710

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2970	Rev A					(4)			

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2970 Dwg Rev: A Prog Rev: A 2-

Deburr if necessary

1010-046

12-7-19

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-7-19

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

SMB
12-7-19

DAS
16
9-02

12/07/19

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2970-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 7/06/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130	Brake NC	0.00				4			SB 12/6/24
Brake NC	Memo	0.00							
	Deburr and form on brake using DT8178 and DT8261as per Dwg D2970								
140	QC5- Inspect part completeness to step on W/O	0.00							
140	QC	0.00							DAS 16 12/4/24
Quality Control	Memo	0.00							
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150	Powdercoat	0.00							MT 12/07/24
Powder Coating	Memo	0.00							
	START TIME: 11:50								
	FINISH TIME: 12:20								

W 12/27/24

3200F

12:20

Dart Aerospace Ltd

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <u>FD-1</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

H ϕ BL 12-7-24

H ϕ BL 12-7-24

MLJ 12/07/25

ME 12-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 86867

Parent Item: D2970-3

Parent Item Name: Wearplate

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B01.06.07Added Material and Tool numberSM/EC
IPP C 08.09.03 Waterjet EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S19GA 1010/1025 SHEET .040		Purchased	No			100	sf	0.0000	1.25	5.263158			

B12-7-19

121780

(4)

Dart Aerospace Ltd

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Dart Aerospace Ltd

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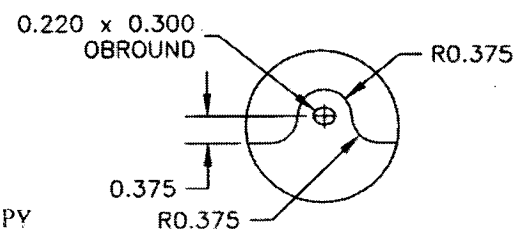
NOTE: Date & initial all entries

DART

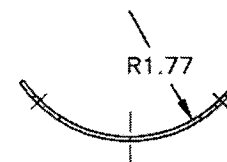


DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
RF	RF	BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO.
00.03.10		D2970
DATE	TITLE	SHEET 1 OF 1
00.03.10	WEARPLATE	SCALE
A	00.03.10	1:10
	NEW ISSUE	

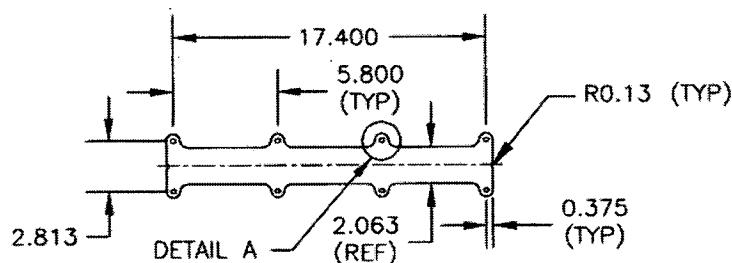
DETAIL A
SCALE 2:5



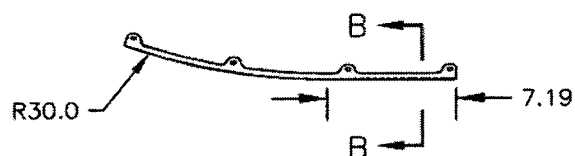
SECTION B-B
SCALE 2:5



D2970-1 FLAT PATTERN

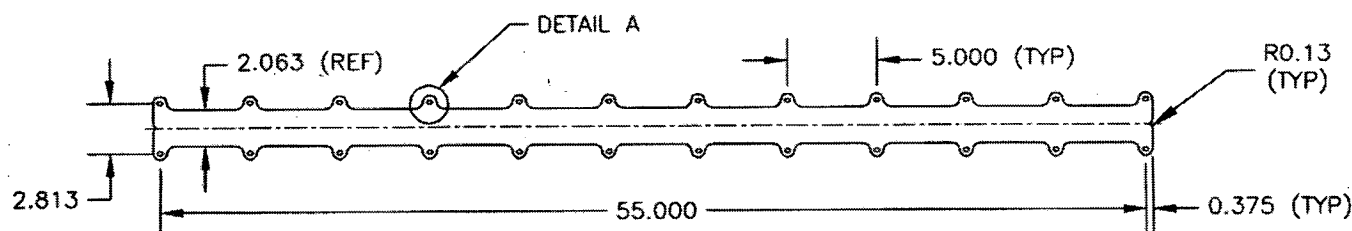


D2970-1 BENDING DETAIL

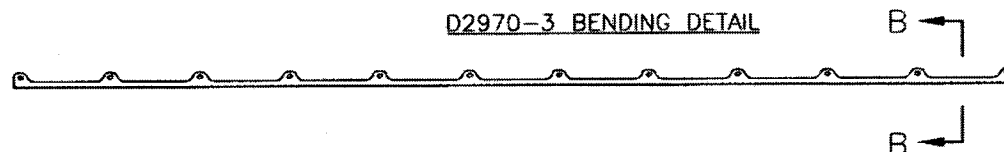


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *86867*
PL 12-07-10

D2970-3 FLAT PATTERN



D2970-3 BENDING DETAIL



BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

RELEASED
00.05.11

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